

Work Order ID 52333

Tuesday, September 22, 2009 1:17:42 PM



Page 1

Item ID: D3414-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lug Assembly

Start Date: 9/23/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: *PL mF*

Date: *09-9-22* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3414

Rev C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3414-1

Dwg Rev: *E*

Prog Rev: *E*

2-Deburr if necessary

IB 9-10-13

13

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-10-13

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Start Date: 9/23/2009 Start Qty: 12.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00

→ 5/2/10/13

QC

Memo

0.00

Quality Control

X13

/

130

0.00

JB 09/10/13

Brake NC

Memo

0.00

Brake NC

1-Deburr

2-Form using DT8254 as per Dwg D3414

13

/

140

0.00

Large Fab

Memo

0.00

Large Fab

1- Weld using location Jig DT8484 as per Dwg D3414
A/R S.S. welding rod Batch: M102000

EL 9-10-21 X13

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Item Name: Lug Assembly

Start Date: 9/23/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

09 10 22

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) S 02/02/23

X13

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-^{Steel}Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 7:00 AM
OVEN TEMPERATURE: 400°C
FINISH TIME: 7:30 AM

09/10/26

X13

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Page 4

Item ID: D3414-041

Accept



Setup Start



Revision ID: C

Stop



Item Name: Lug Assembly

Start Date: 9/23/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

UMP 09/10/2009

113

190

Identify as per dwg & Stock Location: 968

0.00



Packaging

Memo

0.00

Packaging

P 9/14/27 (13)

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09.10.27

P 09-10-27

Picklist Print

Page 1

Tuesday, September 22, 2009 1:17:42 PM

Work Order ID: 52333

Parent Item: D3414-041RevC

Parent Item Name: Lug Assembly


Comments:

Start Date: 9/23/2009

Required Date: 10/9/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S12GA  304/316 0.100" Sheet		Purchased	No			100	sf	21.3500	18.2400	19.76		

B9-10-13

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

21.35

112290

21.35

D3414-3RevB

Manufactured

No

140

Each

43.0000

12.0000

112290

~~112290~~

EL

9-10-21

Lug

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

43

50309

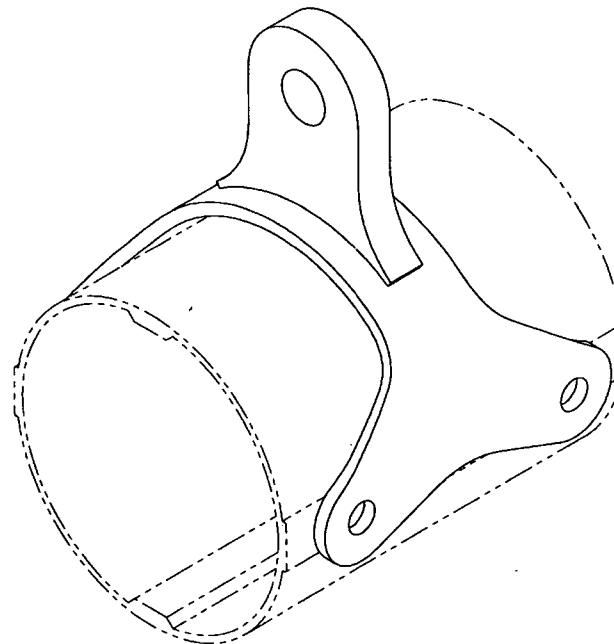
24

50469

19

13

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

NOTES:

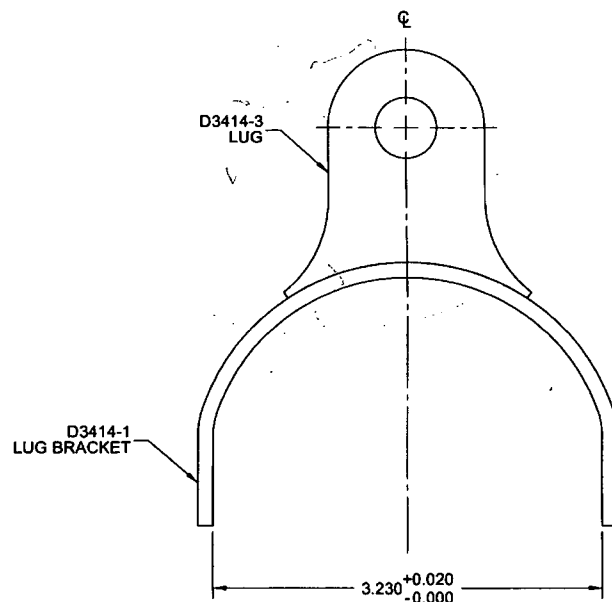
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52333

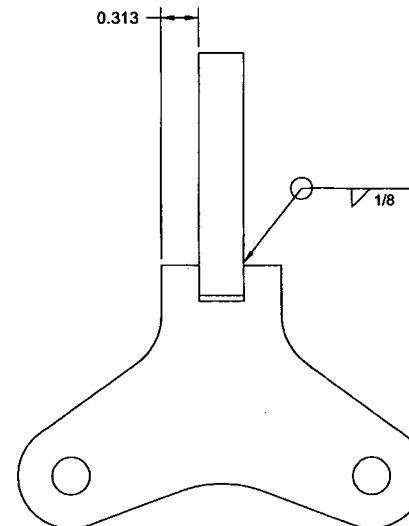
RELEASED
05/16/2017

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	08.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PART 198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3414	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LUG ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

52333



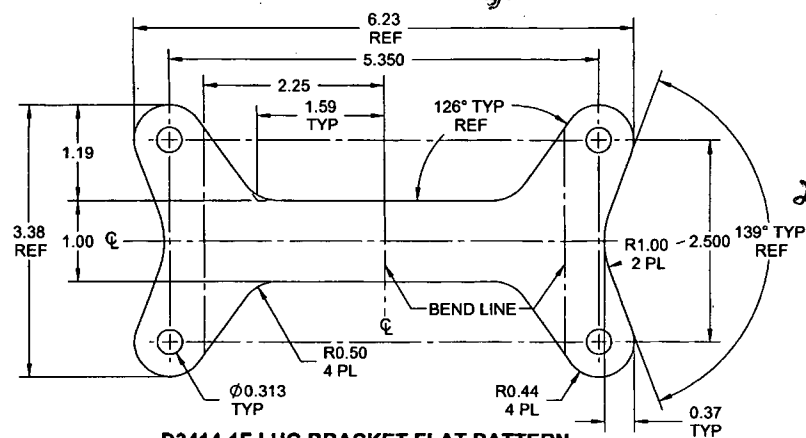
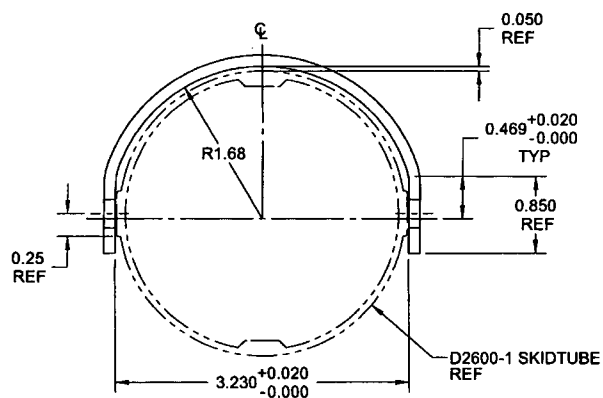
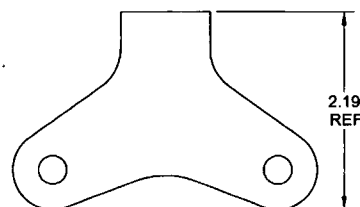
D3414-041 LUG ASSEMBLY



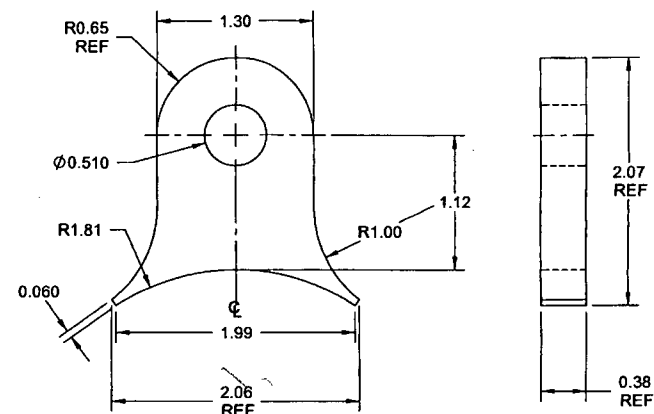
RELEASED
04/18/17

DESIGN	CP	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. C
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52333

**D3414-1F LUG BRACKET FLAT PATTERN****D3414-1 LUG BRACKET**

SIDE VIEW FOR REF ONLY

**D3414-3 LUG**

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

RELEASED

DESIGN	QP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. C
MFG. APPR.	CP	D3414	SHEET 3 OF 3
APPROVED	CP	TITLE	SCALE
DE APPR.	CP	LUG ASSEMBLY	NTS
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